

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000669**Date Inspected:** 22-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance (QA) Inspector observed ZPMC Welder Wu Zhibin, welder identification 049804 welding with the Submerged Arc Welding (SAW) process in the flat (1G) position on the 89 Meter Mock-Up, MUB MA-23 Face C complete joint penetration (CJP) weld. The plates being joined were MA-23-1 and mp512-1 with welding procedure specification (WPS) WPS-B-T-2221-B-U3C-S1. However there is some questions concerning the weld joint number. This is a CJP and normally ZPMC list the weld as XX-A and XX-B giving the same weld number to both sides of the plate, however in this case they gave the number 25 on one side of the plate and 26 on the other the same as they would for a partial joint penetration (PJP) weld. ZPMC's Mr. Shen Xue Jun stated that he was going to bring this weld number up for question tomorrow and would report back his findings. The QC Inspector was observed checking the essential variables which were as follows: voltage 30; amperage 490; travel speed 450 millimeters (mm) per minute and pre-heat 145 degrees Celsius (C).

This QA Inspector observed ZPMC Welders Wang Zhong Hua, welder identification 053753 and Dui Lu, welder identification 048659 welding with the Shield Metal Arc Welding (SMAW) process in the flat (1G) position on the 89 Meter Mock-Up, MUB MA-21 Strut Sub-Assembly CJP weld. The CJP weld numbers being welded were 11A & 11B and 12A & 12B using WPS-B-T-3212-TC-U5B. The QC Inspector was observed checking the essential variables which were as follows: voltage 24.5 & 24.1; amperage 201 & 197; travel speed 127 & 123 mm per minute and pre-heat 192 & 189 degrees C.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer